

# Work Order ID 67761

Wednesday, March 30, 2011 10:33:57 AM



Page 1

Item ID:	D2230-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug					
Start Date:	3/30/2011	Start Qty:	100.00		Cust Item ID:	
Required Date:	4/4/2011	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-31	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D2423 extrusion to 0.82"								
	Batch:								

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA927								
	DWG REV:								
	FOLIO REV:								
	(Check for crack while loading into the machine.)								
	2- deburr rough edges								

Issue 710 to Ymetec  
Machine as per dwg D 2230 REV.G

Pro: 13761

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67761

Wednesday, March 30, 2011 10:33:57 AM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/30/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC  
Quality Control

Memo

0.00

rec'd + inspect for transit damage  
+ attached c/c to w/o

100/100 (100)

130

QC3- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5 u/o 4/02

counts  
100

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

100 of 100 u/o 4/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Required Date: 4/4/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				100		10-4-11.	
160 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo START TIME: 1:40 OVEN TEMPERATURE: 320° FINISH TIME: 2:10.	0.00				100		10-4-11.	
170 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				100		11/9/11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 67761**

Wednesday, March 30, 2011 10:33:57 AM



Page 4

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/30/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: ST 476

0.00



Packaging

Memo

0.00

Packaging

*GP 11/04/14* *(100)*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/14* *(Signature)*

*MF*

*11-04-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, March 30, 2011 10:34:02 AM

Page 1

Work Order ID: 67761



Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	384.5000	0.0683	7.189474			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CL11/03/31

Location

Loc Qty

Loc Code

MAT006

384.5

43722

161.5

45800

1

63005

222

7.19

D2230-1P

x100

*[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

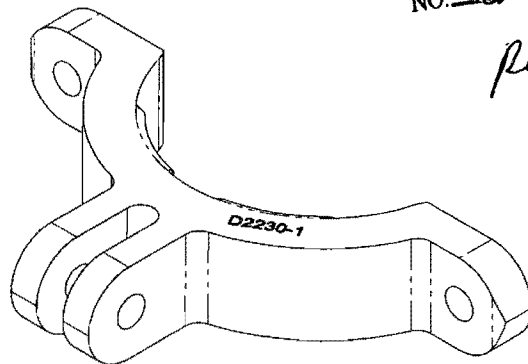
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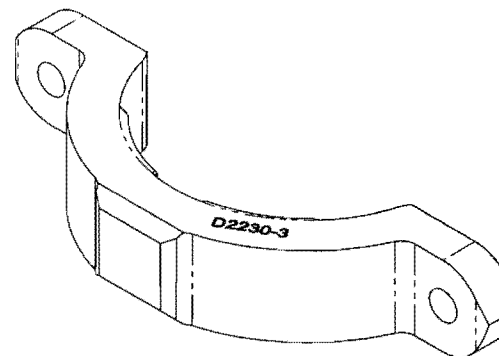
**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67261

*RL 11-03-30*



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
*09/06/25 M*



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION, WITH TOOL TIP RADIUS OF  $0.015 \pm 0.005$ .
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

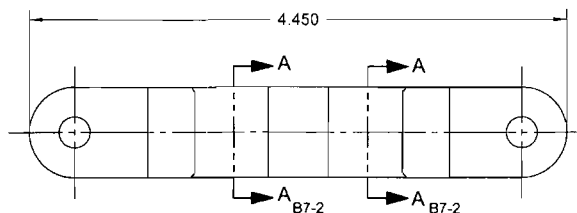
A

D

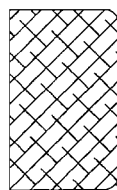
C

B

A



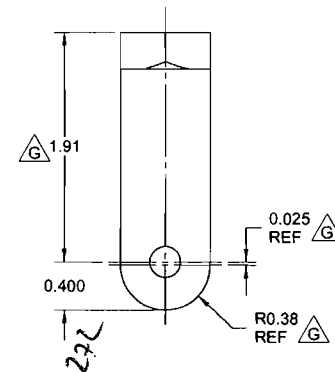
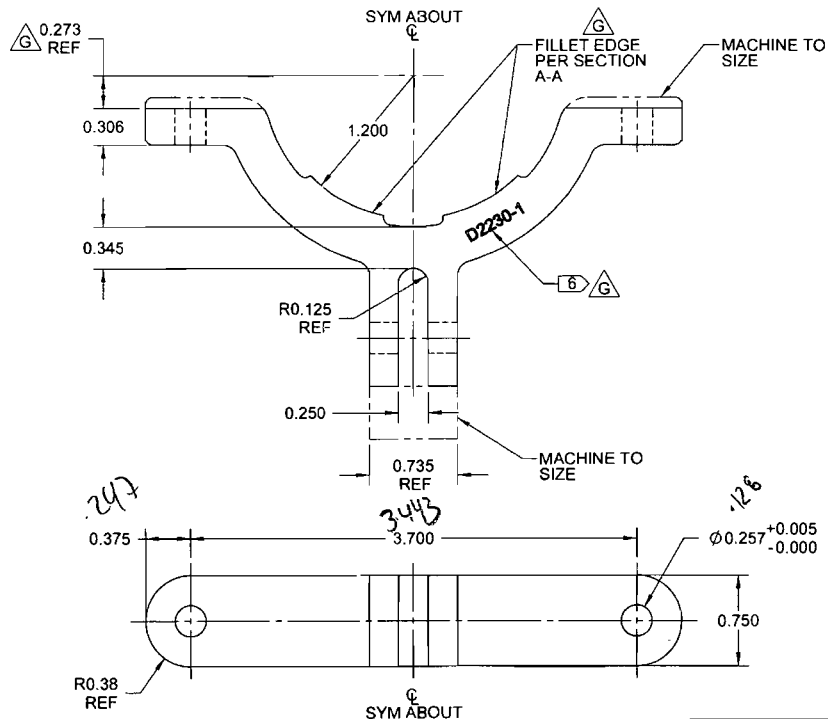
(G)



R0.06 MIN - R0.10 MAX  
2 PL

SECTION A-A D4-2  
SCALE 2X

*w/o g7741*



RELEASED  
09/06/25/11

**D2230-1 MOUNTING LUG**

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

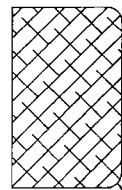
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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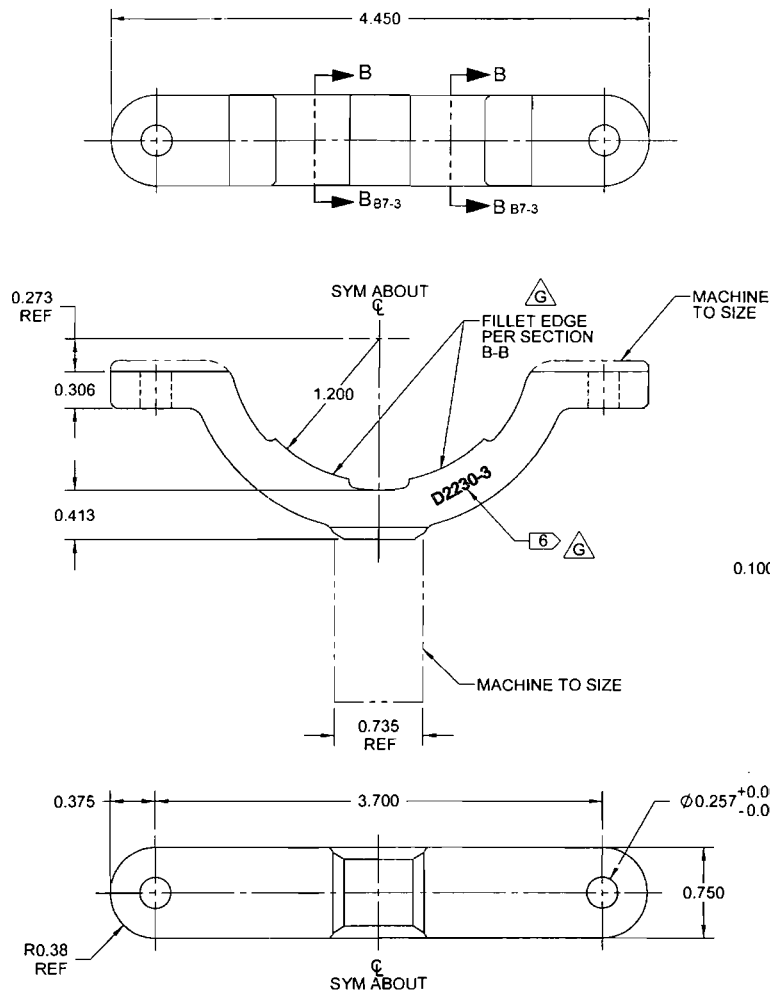
**NOTE:** Date & initial all entries

**SECTION B-B** D4-3  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL

*about*



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/2016

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13761**

Purchase Order Date 3/31/2011

PO Print Date 3/31/2011

Page Number 1 of 1

**Order From :**

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

**Contact Name**

**Vendor Phone**

613 678 3957

**Vendor Fax**

613 678 3956

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
FC 11/10/31

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P (1)	LUG	4/8/2011 Yes	✓ 100.00 Each	Dart Truck <i>4/1/16</i>	\$19.9500	\$1,995.00
		<b>Special Inst:</b> MACHINE AS PER DWG D2230 REV. G B67761					
2	D2230-3P (2)	LUG	4/8/2011 Yes	100.00 Each	Dart Truck	\$13.6000	\$1,360.00
		<b>Special Inst:</b> AS PER DWG D2230 REV. G B67763					

**PO Total:** \$3,355.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

*required ASAP  
please thanks  
Chantal*

*U* *CS*  
Change Nbr: 1 Change Date: 3/31/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable





20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 17869

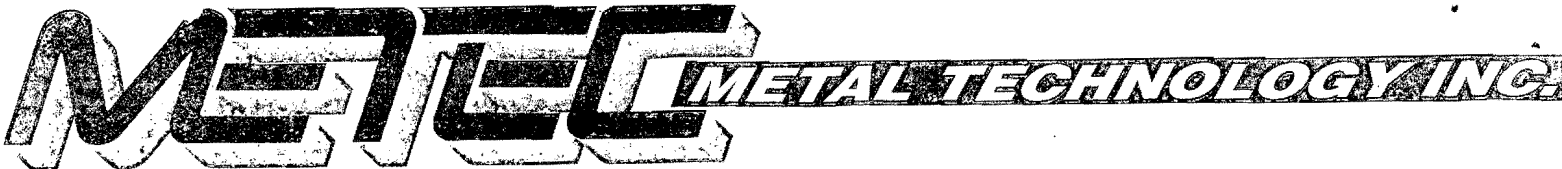
Date: Apr 06, 2011

Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13761	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	100	
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		100
Received by _____		Thank you for your order!		





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-1

Mounting Lug

13761

MATERIAL: supplied by DART D2423 B63005

A handwritten signature in black ink, appearing to read "Shigi Walz", is written over a horizontal line.

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz", is written over a horizontal line.

Shigi Walz

Vankleek Hill, April 6, 2011

